

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029249**Date Inspected:** 13-Mar-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** American Bridge Manufacturer**Location:** Reedsport, Oregon**CWI Name:** David Speakman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Fog Horn Support/Cable hand rail posts**Summary of Items Observed:**

This Quality Assurance Inspector (QAI) James Doe was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

The QAI witnessed work in progress related CCO 61, Fog Horn and Fog Bell Supports:

This QAI observed ABM personnel performing fit up, tack welding operations, and in progress production welding of multiple parts for the Fog Horn and Fog Bell supports. The ABF approved drawing numbers utilized were sheet numbers 5A and 6. The Fog Horn Support, piece mark # 6C1 and the Fog Bell Support, piece mark # 5F1. The ABM Welder was Joe Lacort (ID# EA) and utilizing ABM FCAW WPS #ABM-SAS-07, Rev. 1.

The QAI observed ABM Quality Control Inspector (QCI), Mike Inman monitoring the fit up and welding operations, checking pre-heat and interpass temperatures, perform dimensional and visual inspection. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions.

The QAI witnessed work in progress related to CCO 188 (Cable hand rail posts):

This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the hand rail post's, piece mark VF. The ABF approved drawing sheet # 403D. The ABM Welder was Mike Herbert (ID# H) and utilizing FCAW WPS #ABM-SAS-031 and WPS #ABM-SAS-035.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QAI observed ABM Quality Control Inspector (QCI) Mike Inman monitor the fit up and welding operations, checking pre-heat and interpass temperatures, perform dimensional and visual inspection. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions. This Inspection report was performed by James Doe Lot# B358.



Summary of Conversations:

None unless noted above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Riley,Ken	Quality Assurance Inspector
Reviewed By:	Foerder,Mike	QA Reviewer
